

Date: Thursday, 3/8/2007 1:19:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 31125		Part Number	: D35491	
Estimate Number	: 12634		Drawing Number	: D3549 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/8/2007	S.O. No. : N/A	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/30/2007	
Previous Run	:		Qty:	20	
Written By	:		Um:	Each	
Checked & Approved By	:				
Comment	: Est Rev: A New Issue 06-11-13 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.2205 sf(s)/Unit Total : 2.2050 sf(s) 4.4100

6061-t6-aluminum sheet .080 Sheet

Batch: 01104186

ml 01 06 08

20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3549

Dwg Rev: A

Prog Rev: A

ml 01 06 08

20

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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18

20

PTC

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3549

SB 07/06/13

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-12	40	2 parts scrap. Mild blow-out approximately 0.010" deep, in where the bend is going to be.	AS1042	Scrap. destroy. No replace	OK 07-06-12	OK 07-06-12	AS1042	07-06-12

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31125

Part Number: D35491

Job Number:



Seq. #:	Machine Or Operation:	Description:
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>207-06-14 (18)</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>07-06-15 (18)</i>
8.0	POWDER COATING	POWDER COATING <i>M 104 114 (18)</i>
9.0	QC3	INSPECT POWDER COAT/ CHEMICAL CONVERSION <i>BR/Md 07-06-18 (18) ml 07/06/19 x18</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>ml 07/06/19 (18)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE <i>GA → 2 (16) Slow → 16 ml 07/06/19 (18) ED 07/06/19</i>

Job Completion



U 07-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

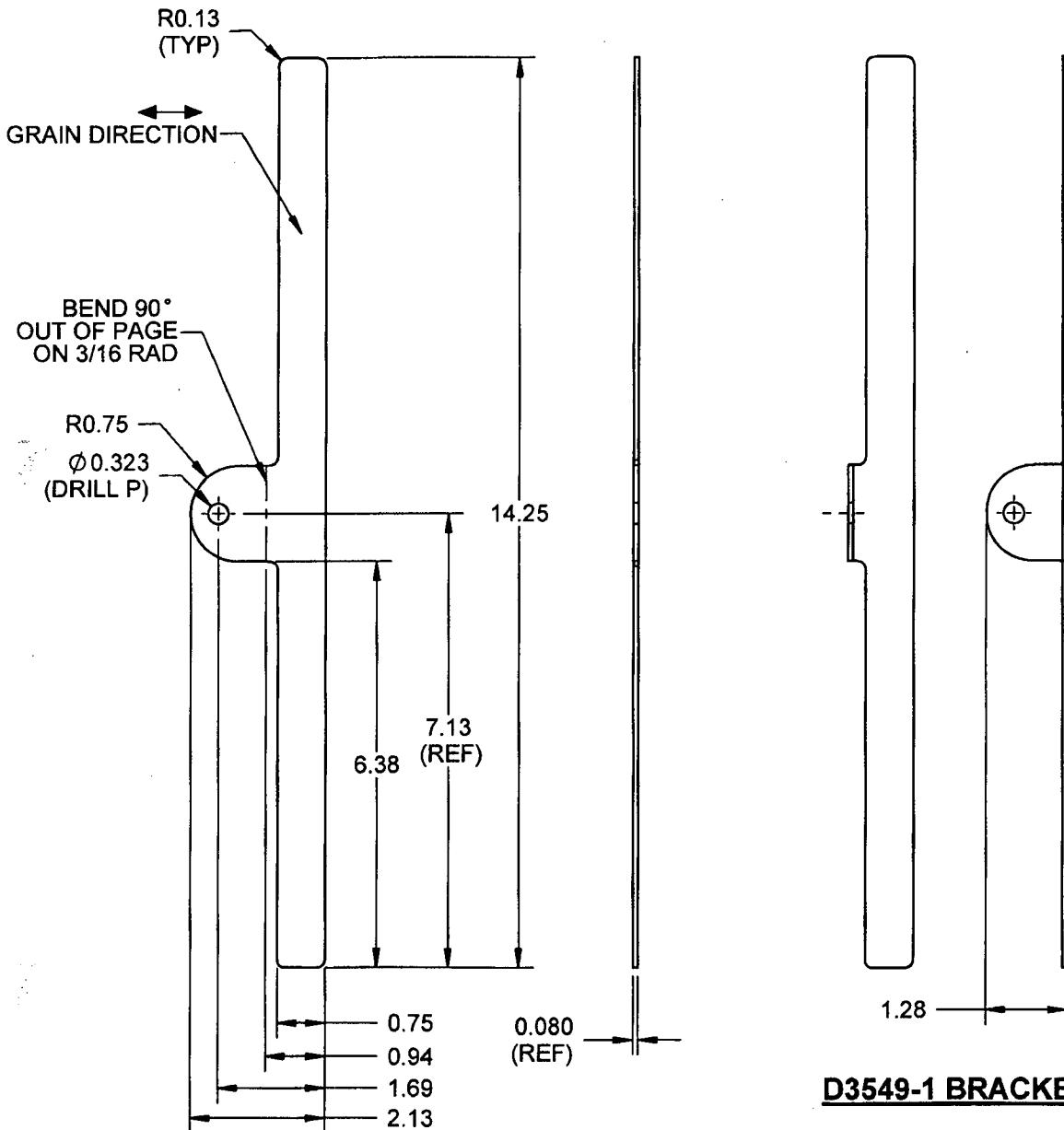
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

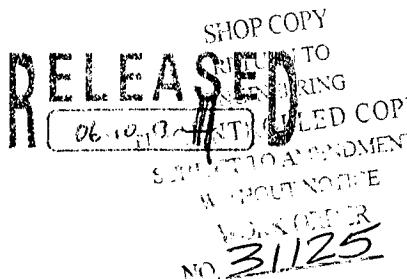
NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3549	REV. A	SHEET 1 OF 1
DATE 06.10.10		TITLE BRACKET	SCALE	1:1
REV A	DATE 06.10.10	DESCRIPTION NEW ISSUE		

**D3549-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.080 THICK PER QQ-A-250/11
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3549-1 USING FINE POINT PERMANENT MARKER

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DART AEROSPACE LTD

Work Order: 31125

Description: Bracket

Part Number: D3549-1

Inspection Dwg: D3549 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

161

 First Article
 Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.75	+/- 0.030	0.755	✓		VERN	
B Ø 0.323	+0.006 -0.001	0.322	✓		VERN	
C 14.25	+/- 0.030	14.25	✓		M.T	
D 1.69	+/- 0.030	1.694	✓		VERN	
E 6.38	+/- 0.030	6.38	✓		M.T	
F R0.13	+/- 0.030	R0.13	✓		R-G	
G 2.13	+/- 0.030	2.132	✓		VERN	
H 7.13	+/- 0.030	7.125	✓		M.T	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. M
Date:	07 06 08

Audited by:	
Date:	

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

Rush-Margie *for Specops* DUPLICATE

Dart Aerospace Ltd.

Date: Thursday, 07/06/2007 10:02:57 AM
User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	31125	Part Number	D35491
Estimate Number	12634	Drawing Number	D3549 REV A
P.O. Number	:	Project Number	N/A
This Issue	07/06/2007	S.O. No.	:
Prsh Rev.	NC	Drawing Revision	A
First Issue	08/03/2007	Type	SMALL /MED FAB
Previous Run	:	Material	:
Written By	:	Due Date	30/03/2007
Checked & Approved By	:	Qty:	10
Comment	Est Rev:A New Issue 06-11-13 EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.2205 sf(s)/Unit Total : 2.2050 sf(s) 6061-t6 aluminum sheet .080 Sheet	
		Batch:	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3549 Dwg Rev: _____ Prog Rev: _____	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form as per Dwg D3549	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/06/2007 10:02:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31125

Part Number: D35491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

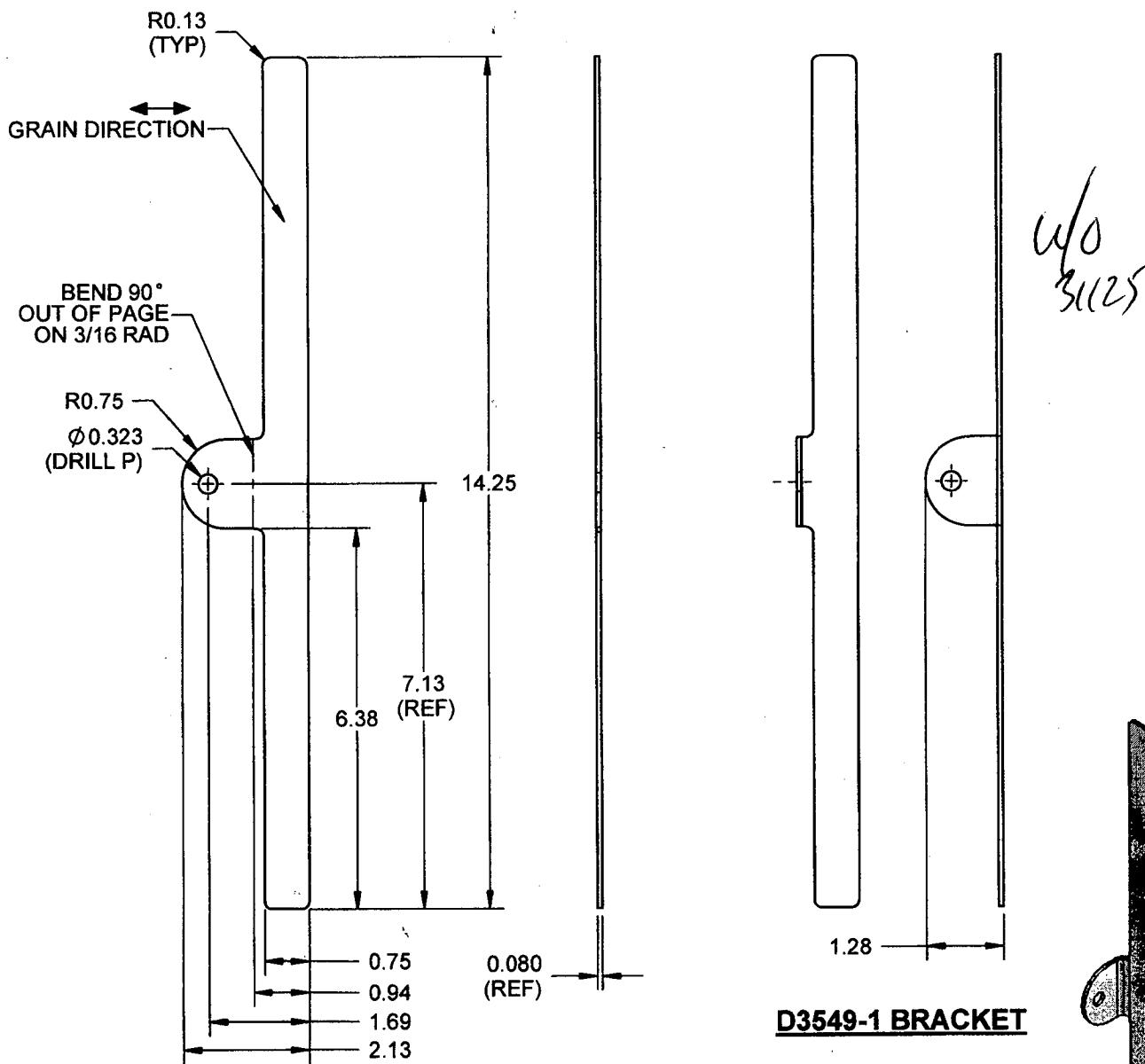
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	D3549	REV. A SHEET 1 OF 1
DATE 06.10.10		TITLE	BRACKET	SCALE 1:1
REV A	DATE 06.10.10	DESCRIPTION NEW ISSUE		

**D3549-1 BRACKET****NOTES:**

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RELEASED
06.10.10

Date: Thursday, 07/06/2007 9:58:28 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 31125		Customer	: Dart Helicopters Services			
Estimate Number	: 12634		DWG Name	: BRACKET			
Purchase Order #	:		Part Number	: D35491			
Complete Date	: / / : : AM		DWG Number	: D3549 REV A			
				Rev.	: A		
DUE DATE		ORDERED		DELIVERED			
30/03/2007		10		0			
2.0 WATER JET		Internal Operation					
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTIME(hrs)	Mach.Cost
11/03/2007	DROU02: Drouin, Steven	Run	0.000	0.10	\$1.61	0.10	9.50
Subtotal:		QTD:	0 CTD:	0	0.10	\$11.11	
				TIME	COST		
		Machine Time:		0.10	\$9.50		
		Labor:		0.10	\$1.61		
		Sub-contract (external Op.):			\$0.00		
		INVENTORY ITEM:			\$0.00		
		SUB-COMPONENT (SUB-JOB):			\$0.00		
Total:					\$11.11		
		COST PER UNIT:			\$11.11		